

plete treatise covering dimensions and design is given in the chapter on "Jig Bushings."

In order to hold the work rigidly in the jig, so that it may be held against the locating points while the cutting tools operate upon the work, jigs and fixtures are provided with clamping devices. Sometimes a clamping device serves the purpose of holding the jig to the work, in a case where the work is a very large piece and the jig is attached to the work in some suitable way. The purpose of the clamping device, however, remains the same, namely, that of preventing any shifting of the guiding bushings while the operation on the work is performed. The clamping device should always be an integral part of the jig body in order to prevent its getting lost. Different types of clamping devices are shown and described in the chapter on "Jig Clamping Devices/

The locating points may consist of screws, pins, finished pads, bosses, ends of bushings, seats, or lugs cast solid with the jig body, etc. The various types used are\* described in detail in the chapter on "Locating Points and Adjustable Stops/